

Title (en)
METHOD AND DEVICE FOR HOLDING A WORK PIECE ON A MOVABLE PALLET

Publication
EP 0168687 A3 19860205 (DE)

Application
EP 85107910 A 19850626

Priority
CH 314184 A 19840629

Abstract (en)
[origin: EP0168687A2] 1. Equipment for the fastening of a workpiece (41) on a movable workpiece pallet of a palleting equipment, consisting of several workpiece pallets which are feedable in stepwise manner to the treatment station of a numerically controlled machine tool, wherein the equipment is associated with an independent loading appliance set up outside the palleting device and a clamping unit, which is arranged on a base plate (30), is couplable with the loading appliance and consists of at least one store (12), a filling valve (1), at least one control valve (2, 3, 4, 5) and at least one clamping cylinder (20) connected through at least one connecting duct, characterized thereby, that an hydraulic loading appliance and an hydraulic clamping unit are provided and that the clamping unit displays a first duct branch, which serves for the charging of a supporting cylinder (19) and is equipped with a biased store (9) and a control valve (2) actuatable from the machine tool by an actuating fork (42), and a second duct branch, which serves to the charging of at least one clamping cylinder (20) and is equipped with control valves (3, 4), serving for a preset partial relief and actuatable by the actuating fork (42) of the machine tool, with a pressure-limiting valve (16) and a volume-compensating cylinder (18) and with control valves (3, 4, 5), which serve for a reduced preset recharging and are actuatable by the actuating fork (42), a second biased store (12), a second pressure-limiting valve (17) and the volume-compensating cylinder (18).

IPC 1-7
B25B 5/06; B23Q 3/08

IPC 8 full level
B23Q 3/08 (2006.01); **B25B 5/06** (2006.01)

CPC (source: EP)
B25B 5/064 (2013.01)

Citation (search report)
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Designated contracting state (EPC)
AT DE FR GB IT

DOCDB simple family (publication)
EP 0168687 A2 19860122; EP 0168687 A3 19860205; EP 0168687 B1 19890426; AT E42489 T1 19890515; CH 664724 A5 19880331; DE 3569692 D1 19890601

DOCDB simple family (application)
EP 85107910 A 19850626; AT 85107910 T 19850626; CH 314184 A 19840629; DE 3569692 T 19850626